

19/08/2008 4:04:41 PM

Process Sheet

DAR001 Dart Helicopters Services		Drawing Name	: STEP SPACER	
41445D		Part Number	: D30657	
10380		Drawing Number	: D3065 REV. B	
19/08/2008	S.O. No. :	Project Number	: N/A	
NC	Type : SMALL /MED FAB	Drawing Revision	: B	
First Issue : //		Material	:	
Previous Run : 39861D		Due Date	: 30/09/2000	Qty: 50 Um: Each
Written By :				
Checked & Approved By :	<u>JUD 08-8-19</u>			
Comment :	Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF Est Rev:D Now on Water Jet 06-04-11 JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S040	2024-T3 .040 sheet
Comment: Qty.: 0.1653 sf(s)/Unit Total : 8.2635 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch: <u>107461</u> HB 8-10-31		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3065 Dwg Rev: <u>B</u> HB 8-10-31 Prog Rev: <u>B</u> 2-Deburr if necessary HB 8-10-31		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE HB 8-10-31		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK 06-11-03 (62) P10		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary.		
DONE AT STEP 2.2		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3065-7 PAR #: N/A Fault Category: Prod/Med & Small NCR: Yes No DQA: D Date: 08/12/22
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: D Date: 08/12/23

NCR: <u>41445D</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08-11-03</u>	<u>20</u>	<u>1 part scrap.</u> <u>Blow out on 2 hole</u> <u>RC: Machine set malfunction</u>	<u>[Signature]</u> <u>05/11/23</u>	<u>Scrap & destroy</u> <u>No replace</u>	<u>[Signature]</u> <u>08/11/03</u>	<u>[Signature]</u> <u>06-11-03</u>	<u>[Signature]</u> <u>05/11/23</u>	<u>[Signature]</u> <u>06-11-03</u>

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:04:41 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 41445D

Part Number: D30657

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3065

SB 08/12/15

(62)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 08/12/16

counter

(462)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FD 08/12/17

(62)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

M-D

08/12/17

(62X)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

GA
Sylvie

SS 08/12/18

(X62)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/18

Job Completion



MF 08-12-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			


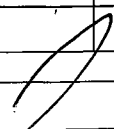
NOTE: Date & initial all entries



DART AEROSPACE LTD		Work Order: 414450	
Description: Step Spacer		Part Number: D3065-7	
Inspection Dwg: D3065 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.000	.131	X			
0.865 (Pitch)	+/-0.005	.863	X			
4.522	+/-0.010	4.521	X			
0.250	+/-0.010	.250	X			
2.093	+/-0.010	2.091	X			
3.936	+/-0.005	3.936	X			
4.186	+/-0.010	4.188	X			
Ø1.250	+/-0.005	1.253	X			
R0.125	+/-0.010	.125	X			
Grain Direction	N/A	Good	X			

Measured by: 	Audited by: 	Prototype Approval:	N/A
Date: 8-10-31	Date: 08-11-03	Date:	N/A

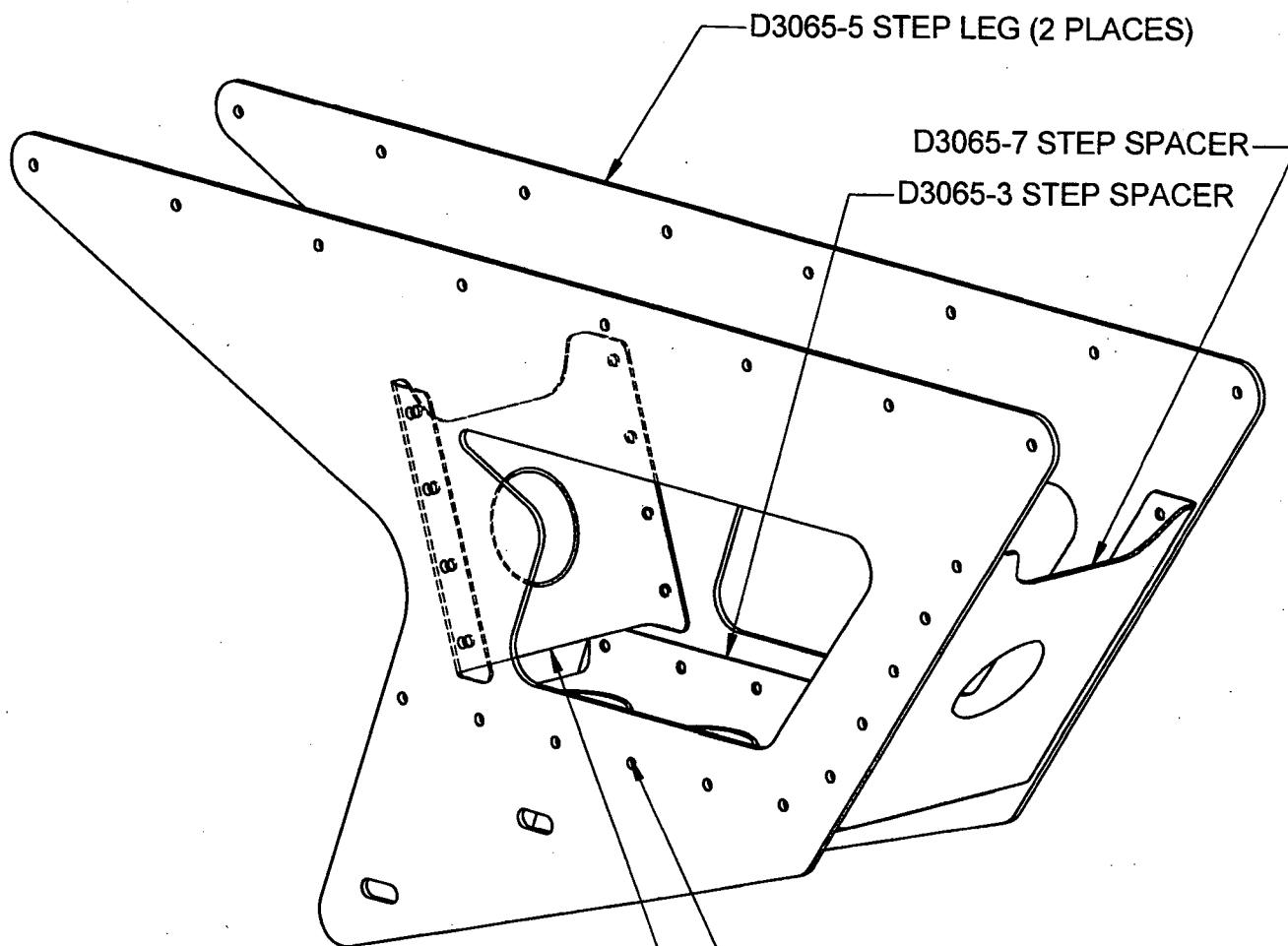
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	04.05.15	Removed 0.531, 3.686, 0.580; Added 3.936 dimensions	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM 	



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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 *[Signature]*



D3065-1 STEP SPACER

ASSEMBLE WITH
MS20470AD4-4 RIVET
(30 PLACES)

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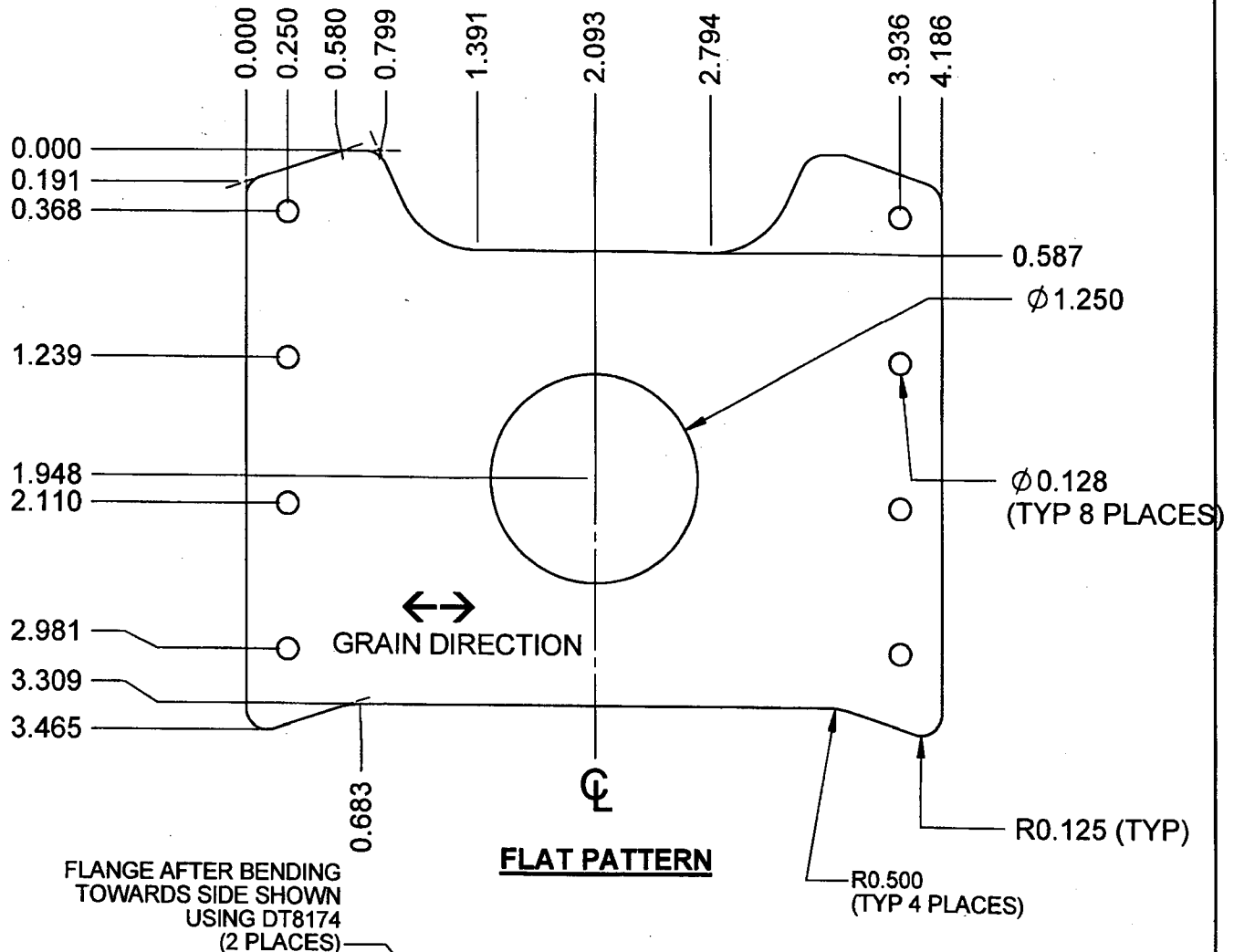
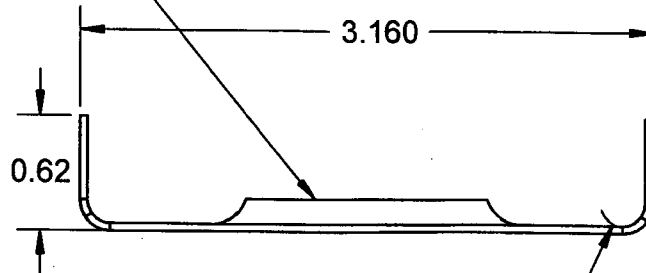
D3065-041 STEP LEG ASSEMBLY

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DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

**RELEASED***cl. de-20***D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

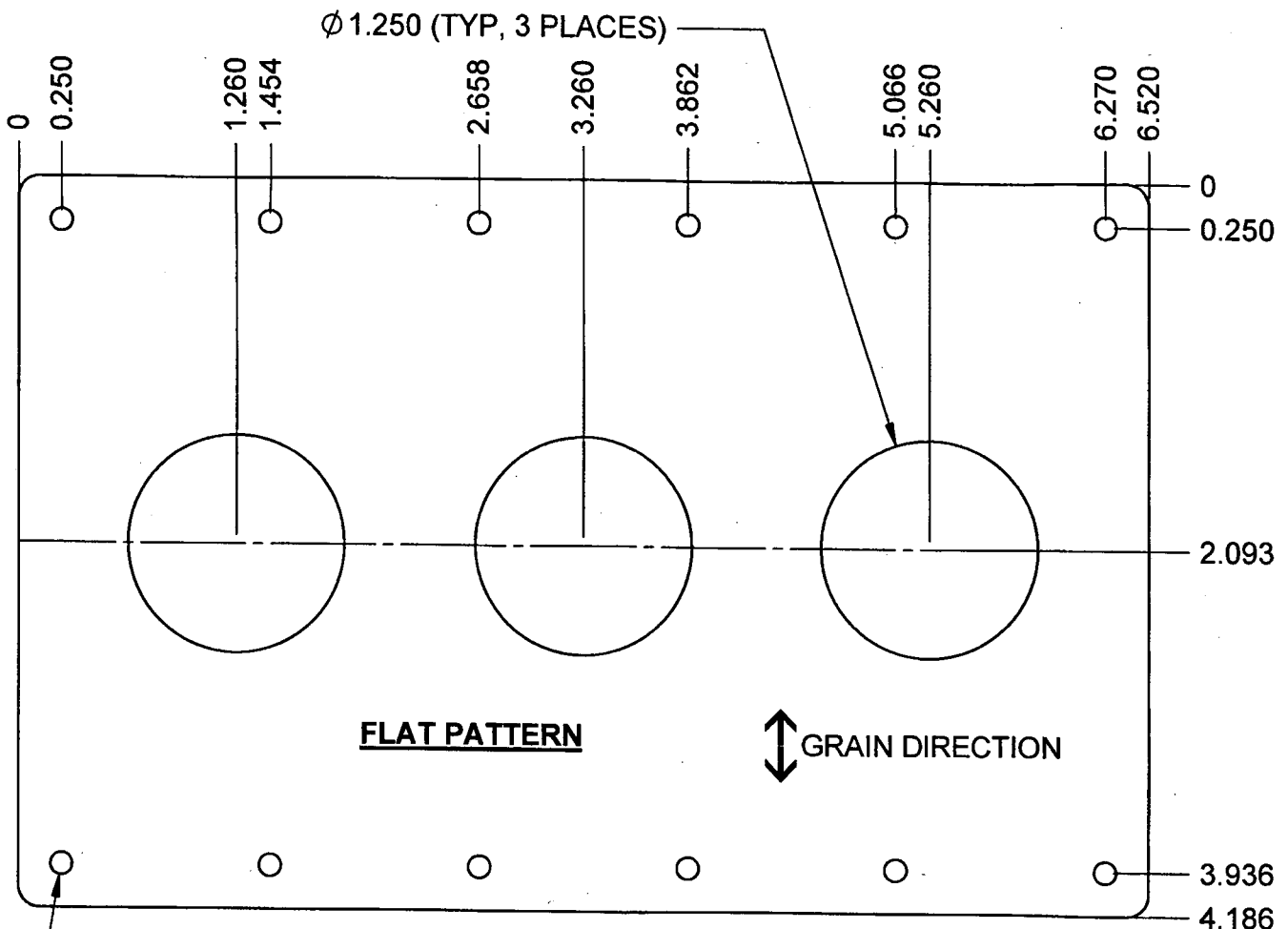
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DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SHEET 3 OF 5 SCALE 1:1

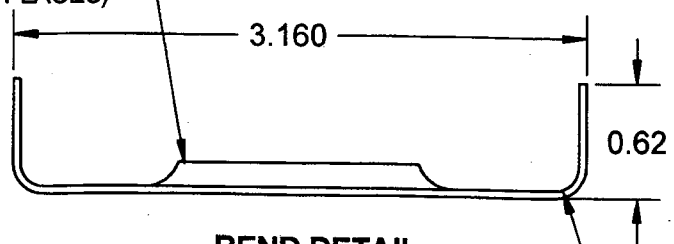


FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

RELEASED

06.06.20



BEND DETAIL

D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

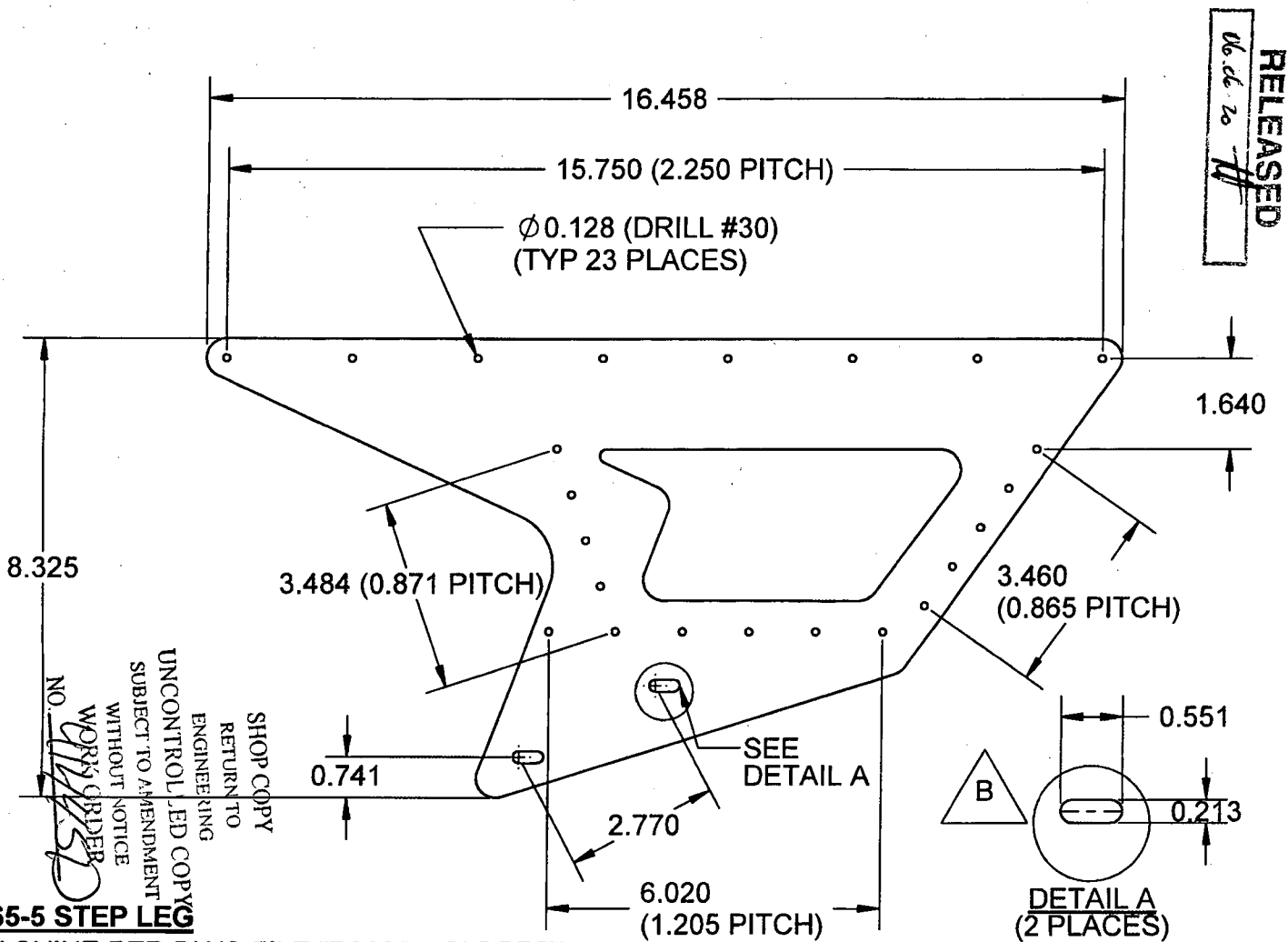
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CHECKED	APPROVED	DRAWING NO.	REV. B
PH	<i>[Signature]</i>	D3065	SHEET 4 OF 5
DATE	06.05.23	TITLE	SCALE
		STEP LEG ASSEMBLY	1:3

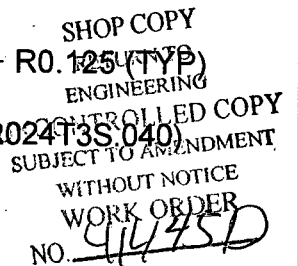
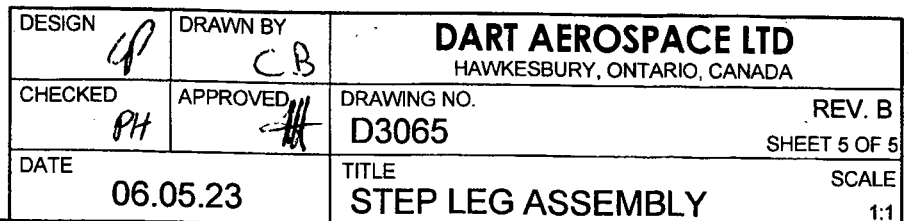


D3065-5 STEP LEG

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

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